



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Order 5296

RBW6205G11451-3G
Job Sheet 177012



Part No: RBW6205G11451-3G

Job Qty: 8 ea

DAS
13
0-00

Part Name: Clamp



MAY 07 2018

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G11451-3G REV 1 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Machining	N/A	
92	Purchasing	8 pcs	6/8/18	6/8/18	0.00	0.00	Purchasing		<i>AC 18/06/18</i>
94	Packaging	8 pcs	6/8/18	6/8/18	0.00	0.00	Packaging2		<i>7/18/06/18</i>
96	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC6		<i>38</i>
108	Bandsaw	8 pcs	6/8/18	6/8/18	0.00	0.00	Bandsaw1		<i>3-38</i>
110	Mori Seiki	8 pcs	6/8/18	6/8/18	0.00	1.33	MORI NV5000-1		
120	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC2 Machining-1		
130	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC8 Machining-1		
140	Outsource	8 pcs	6/8/18	6/8/18	0.00	0.00	Outsource4		
150	Packaging	8 pcs	6/8/18	6/8/18	0.00	0.00	Packaging2		
160	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC6		
180	Packaging	8 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-1		<i>GA-100 18-06-12</i>
190	QC21-SA	8 Ea	6/8/18	6/8/18	0.00	0.00	QC21		<i>DAS JUN 12 2018</i>

Part Op 92 - 1- Issue P/O to Arrow Tech Machine Works P/O# 039826 2- Manufacture RBW6205G11451-3G as per
Descriptions: DWG 3- Certificate of conformity is required

108 - 1- Cut blank at 8.25", 1 blank makes 6 parts

110 - 1-Machine as per folio FB _____ FOLIO REV: _____ DWG REV: _____ 2-Deburr

140 - -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water
sealant -Certificate of Conformity is required

08 Mai 2018 x 16 R. L.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X1.000	6061T6 Bar 1.000 X 1.000	5.4960 ft (.687 ea)	90-Start up Operation	
RBW6205G11451-3GP	Clamp	8 Ea (1 ea)	90-Start up Operation	<i>5078250</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X1.000	5	19	0
	RBW6205G11451-3GP	8	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Completed By	
DART Aerospace Ltd. 1270 Aberdeen Street Aberdeen, ON K6A 1K7 CANADA TEL: 1 813 622-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/07/18 Container No: S078977 Part: RBW6205G11451-3G Job No: 177012 Serial No/Batch: S078977 Revision: 1 Inspector: _____ Exp Date: 06/07/2018 Instructions: _____				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
				Positioned Wrong	
Outside Dimensions					
Over/Under tolerance					
Part Incorrect					
Part Lost/Missing					
Part Moved					
Drawing					
Finish					
Misread					
Turning Sequence					

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Heat Treat ☐

Wave/Twist in Tube ☐

Marks/Chatter ☐

Contamination ☐

Countersink ☐

Cut Too Short ☐

Instructions Incomplete/Unclear ☐

Drill Holes ☐

Unqualified ☐

Wrong Stock Pulled ☐

Out of Sequence ☐

Off-set ☐

Mislabeled ☐

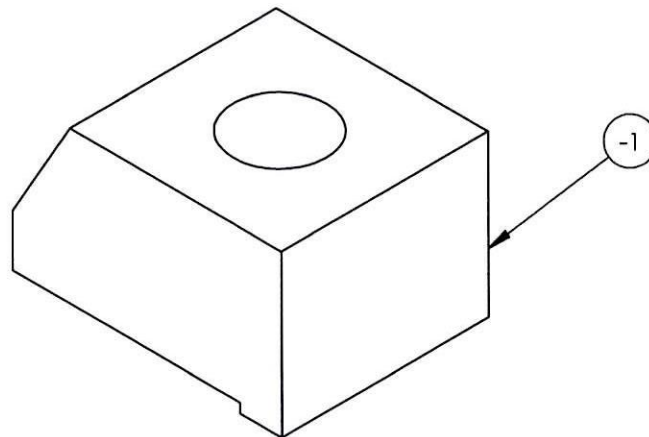
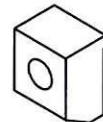
Fit/Function ☐

Misaligned/off center ☐

OTHER : _____

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CH'D ENGRAVE NOTE ADDED S/N, MADE IN USA.	1/19/2010	RJC	RW
B		-1 CH'D BOM INFORMATION.	5/25/2011	RJC	RW
1	15-0174	-1 CH'D BOM QTY. WAS 8 IS 1, DELETED CLAMP SET.	7/15/2015	RJC	JAG



NOTE:

1. REF. AGUSTA T/N: 3G6205G11451.
2. ALSO PART OF KIT RBW6205G15231-3G.

DART AEROSPACE	
TITLE CLAMP	
DWG NO. RBW6205G11451-3G	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 2:1	DATE 4/30/2010 SHEET 1 OF 2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	CLAMP	6061		2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



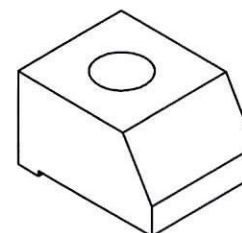
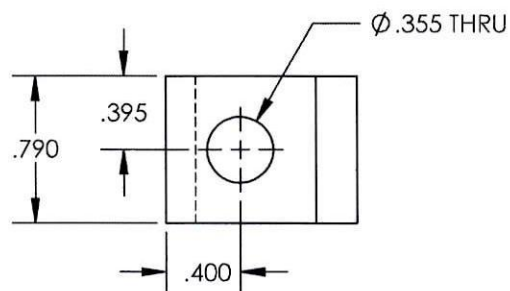
QA Closed: _____ Date: _____

Work Order update only ☐

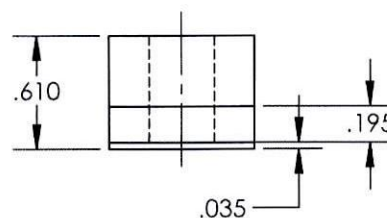
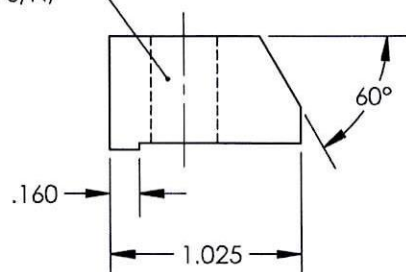
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CH'D ENGRAVE NOTE ADDED S/N, MADE IN USA.	1/19/2010	RJC	RW
B		-1 CH'D BOM INFORMATION.	5/25/2011	RJC	RW



ENGRAVE T/N, S/N,
MADE IN USA



(-1)
CLAMP

DART AEROSPACE	
TITLE CLAMP	
DWG NO. RBW6205G11451-3G-1	REV 1
MAT'L 6061	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:1	DATE 4/30/2010 SHEET 2 OF 2

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		OTHER :							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039826**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039826
PO Date: 5/8/18
Due Date: 6/4/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick
Phone:

E-MAILED
MAY 07 2018

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		RBW6205G11451-3GP	Clamp As Per Dwg RBW6205G11451-3G Rev. 1	Firmed	6/4/18	16 Ea 16x	0 Ea	16 Ea	\$83.64/Ea	\$1,338.24
Line Item Note W/O 177012										
2		RBW6205G13231-3GP	Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	6/4/18	6 Ea 6x	0 Ea	6 Ea	\$413.50/Ea	\$2,481.00
Line Item Note W/O 177008										
3		RBW6205G12731-3GP	Upper Plate Assembly As Per Dwg RBW6205G12731-3G Rev. 3	Firmed	6/4/18	2 Ea 2x	0 Ea	2 Ea	\$2,595.37/Ea	\$5,190.74
Line Item Note W/O 177007										
									Grand Total:	\$9,009.98

Order Notes

re'd 11/4/16/17

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

[Signature]

Plex 5/8/18 11:39 AM dart.Lussier.Patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039826

Dated: 06/05/2018

Our Order / Job No:039826-2AWT

Order Qty: 16

Part Name: CLAMP

Part Number: RBW6205G11451-3G

Lot Size: N/A Ship Date: 6/5/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G11451-3G Rev: 1

Material Size and Type:-1/ 6061 ALUM.

Material Specifications: ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 6/5/18

Signed: *Hemant M. Patel*

DAS
38
9-88

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com